

5/45

DART AEROSPACE LTD	Work Order:	24638
Description: Prop Arm	Part Number:	D2730
Drawing: D2730 rev.B1	Qty:	20

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	FF	05.10.21	20
2	METAL	Punch 304/316 Seamless Tubing, 1/2" O.D. x 0.035" wall to length as per Dwg D2730 M18796 (2) Batch M18033 (13)	FF	05.11.02	20
3	METAL	Drill as per dwg D2730	FF	05.11.03	20
4	METAL	Deburr	FF	05.11.03	20
5	QC	Inspect Level 5	2	05.11.07	20
6	FINISHING	Powder coat white (Ref 4.3.5.2) per QSI 005 4.3	ML	06.01.31	20
7	QC	Inspect Level 3	6/2/1	20	
8	STORES	Identify and stock Loc 147	6/2/1	20	
9	EXPEDITING	Close W/O Inspect level 21 Cost / part Sur 06/02/02 (20)	LD	06/02/02	20

Rev	Date	Change	Revised By	Approved
A		New issue (ipp-038)		
B	00.01.12	Re-format	EC	
C	00.07.07	Re-format, rev.B dwg (MPP 2074)	EC	
D	02.04.16	Added dwg Rev.B1	NG	02-04-17

RELEASED

02/04/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/02/02

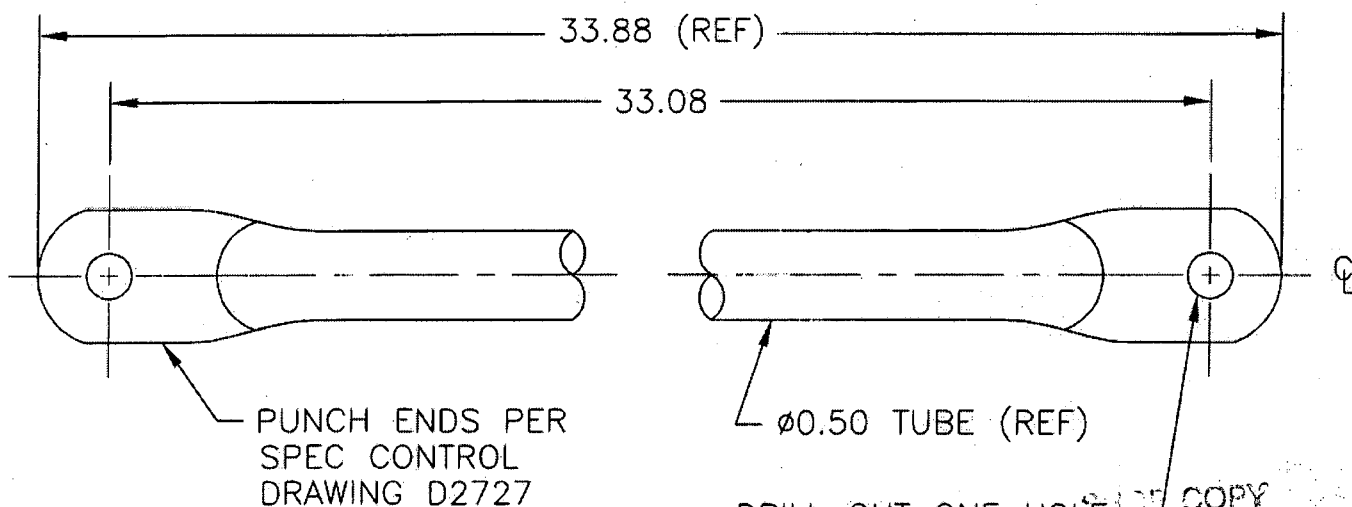
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2730	REV. B SHEET 1 OF 1
DATE 00.06.20		TITLE PROP ARM	SCALE NTS
A	98.04.20	NEW ISSUE	
B	00.06.20	33.88 WAS 33.25; 33.08 WAS 32.45	
B1	<i>CPH</i> 02.03.22	ADD FINISH	

RELEASED
00-06-27 *[Signature]*



DRILL OUT ONE HOLE
USING 'Y' DRILL (Ø0.404)

1. REELED COPY
2. RETURN TO AMENDMENT
3. WITHOUT NOTICE

WORK ORDER

NO. 24638

MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.50 x 0.035 WALL
ENSURE SEAMLESS TUBE IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 *[Signature]*

Copyright © 1988 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 20, 2005
04:09 pm

Work Order No : 0024638
Project Name : D2730
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2730
Description : Door Prop
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-11-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:42 pm

Work Order No : 0024638
Project Name : D2730
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2730
Description : Door Prop
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-11-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	3.00	100.00		
Production Cost :	0.00	44.61	100.00	0.00	44.61
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	44.61	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	44.61			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-44.61)

WKS 8/B
u
11-13

Date: Monday, 14/11/2005 8:11:32 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PROP ARM
Job Number :	24638		
Estimate Number :	10321		
P.O. Number :		Part Number :	D2730
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2730 REV B1
First Issue :	//	Project Number :	
Previous Run :		Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	30/11/2005
Written By :		Qty:	20
Checked & Approved By :		Um:	Each
Comment :	Est D 02.04.16 Added dwg Rev.B1 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
2.0	BRAKE NC	NC BRAKE
Comment: BRAKE NC Punch to length as per Dwg D2730		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill as per dwg D2730 2-Deburr		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
5.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT		
7.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

Date: Monday, 14/11/2005 8:11:32 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ARM

Job Number: 24638

Part Number: D2730

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



